

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE
Job Number	: 34191		
Estimate Number	: 12931		
P.O. Number	: N/A	Part Number	: D29332UP
This Issue	: 8/21/2007      S.O. No. : N/A	Drawing Number	: D2933 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A      Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	: N/A	Material	: N/A
Written By	: <u>[Signature]</u>	Due Date	: 9/20/2007      Qty: 10      Um: Each
Checked & Approved By	: <u>[Signature]</u>		
Comment	: Est Rev: A      New Issue 07-07-04 JLM		

Job Number:

Seq. #:	Machine Or Operation:	Description :
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10 D6101001 7075-T7351 2X6X6.25

Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Issue material from stock: 7075-T7351 QQ-A-250/12

Cut Size 2.0 x 6.25 X 6.00

Grain Along Long 6.00 Length

Batch No: 31386

36 07.09.12 (10)

20 HAAS1 HAAS CNC VERTICAL MACHINING #1

**Comment:** HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

## 5-Deburr

BG 07.09.12 (10)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

4.0 QC1 INSPECT ALL DIM TO DIM SHEET

**Comment:** INSPECT ALL DIM TO DIM SHEET

36 07.09.12 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 12 Date: 07/09/14  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 34191

Part Number: D29332UP

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

8F 07/09/13

(10)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FOL

07/09/13

(10)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

2 07-09-13

(10)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

U

07-09-13

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/09/14

(10)

Job Completion



U 07-09-13

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	34191
<b>Description: 206 Saddle, Inboard, Right side</b>	<b>Part Number:</b>	D2933-2
<b>Inspection Dwg: D2933 Rev. C</b>		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.124	.124	.124	.124		
B	0.100	0.140		.123	.123	.123	.123		
X C	0.100	0.140		.130	.130	.130	.130		
D	0.210	0.230		.223	.223	.223	.223		
X E	1.245	1.255		1.250	1.250	1.250	1.250		
X F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
X H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.259	.259	.259	.259		
X L	0.312	0.317		.314	.314	.314	.314		
X M	0.235	0.240		.239	.239	.239	.239		
N	0.100	0.140		.125	.125	.125	.125		
O	0.540	0.560		.550	.550	.550	.550		
X P	0.490	0.510		.499	.500	.500	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.500	2.500	2.500	2.500		
S	0.240	0.270		.252	.252	.252	.252		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		0.319	0.319	0.319	0.319		
X	1.125	1.145		1.138	1.138	1.138	1.138		
Y	1.565	1.585	DT8695 A/B	1.575	1.575	1.575	1.575		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	36
Date:	07.09.12

Audited by:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	34191
<b>Description:</b> 206 Saddle, Inboard, Right side	<b>Part Number:</b>	D2933-2
<b>Inspection Dwg:</b> D2933 Rev. C		Page 1 of 1

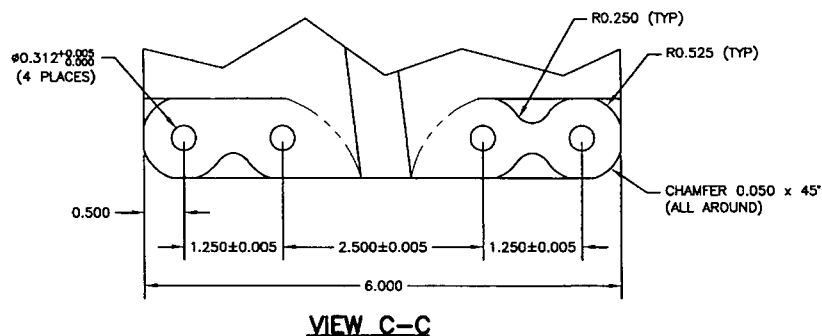
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P	0.490	0.510		.500	.500	.500	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.500	2.500	2.500	2.500		
S	0.240	0.270		.252	.252	.252	.252		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.319	.319	.319	.319		
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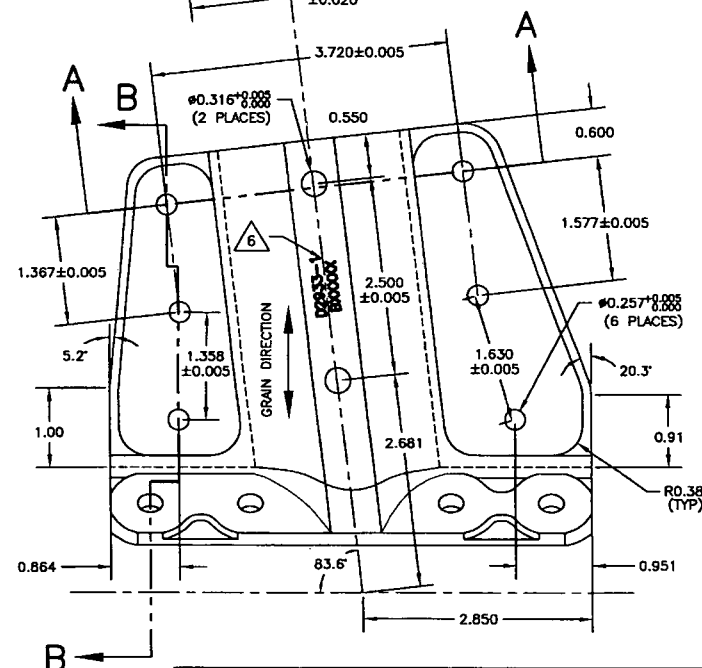
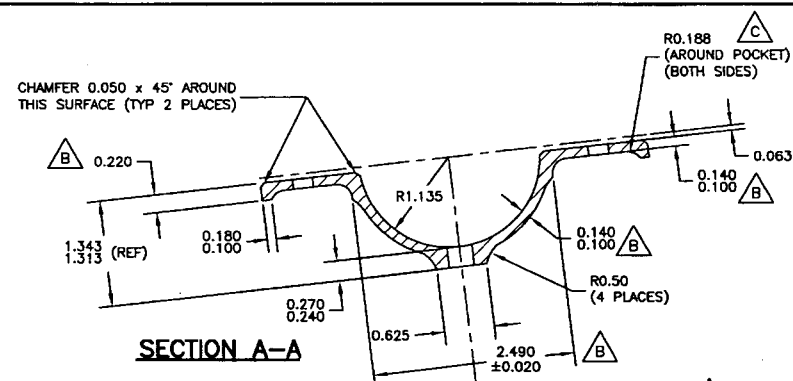
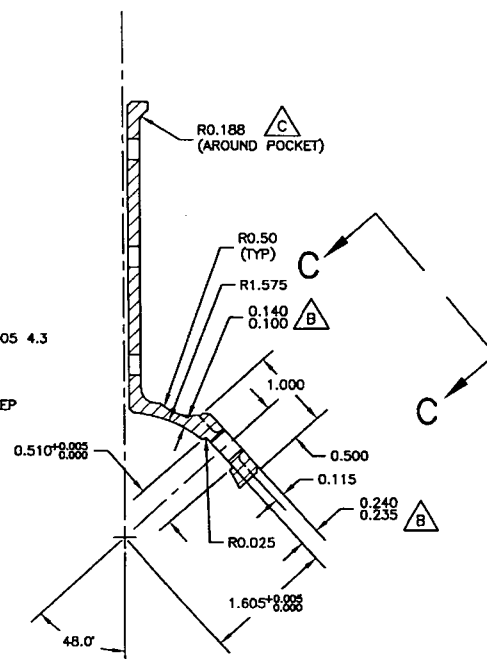
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C	07.03.21	Revised per drawing revision C	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>



**D2933-1 LH SADDLE (SHOWN)**  
**D2933-2 RH SADDLE (OPPOSITE)**

- NOTES:**
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
 (MAKE FROM D6101-001 SADDLE BILLET, 7075)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
  - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC.
CHECKED	APPROVED	D2933
DATE	06.11.09	SADDLE INSIDE

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DART DART AEROSPACE USA, INC. BELLEVUE, WA

REV. C  
 SHEET 1 OF 1  
 SCALE

NO. 34191  
 WORK ORDER  
 WITHOUT NOTICE  
 SUBJECT TO AMENDMENT  
 UNCONTROLLED COPY  
 ENGINEERING  
 RETURN TO  
 SHOP COPY

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 34191
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